Work Ord Monday, Augus					Page 1						
Item ID: Revision ID: Item Name:	D3575-1 Cargo Floor F	Protector		Accept	*N900	040	110	ን* ፡			IS1*
Start Date: Required Date: Reference:	8/13/14 : 8/18/14	Start Qty: 2.00 Req'd Qty: 2.00	*9* *9*		Cust Item :	ID:				* " \	IS2*
Approvals:	Process Pla	nn: MLS	Date: 14-08-19 Date:	Tooling: _ SPC (Y/N):	_	ate:		F		op	IR1* IR2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr D3575 100 *100*	Rev	rision Nbr A FLOW WATER JET		0.00					-		
Waterjet FLOW CNC Waterj	et		RE SIDE UP*** T Dwg D3575 A	0.00						_ <u>bc</u> /	<u>14/10/14</u>
110 *110* QC		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				(2)		De l'	ylioly

0.00

Memo

Quality Control

DQA:			Date:											TRAGG"
						WORK ORDER NON-	-CC	ONFO	RMANCE / UI					AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only	
Work Orde	ır.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS	
WOIR Olde	·' -					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap		ı	Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1	Thern	noforming	Finishing		Rec/Stor	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desc	Iription of work order update		nitial	Act	ion		Sign &		
Cause		Date	Step	Qty		or non-conformance	ı	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design			·	,										
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material									İ					
Operator														
Offset/Setup	Ш			ł										
Process												}		
Supplier					Ì				•				 	
Training	\Box													
Transport					i									
Unapproved					<u> </u>									<u> </u>
							FA	ULT CA	TEGORY				·	
Landi		1				General		1/5	\			Outside Dim		Pressure/Forced
	\vdash	Bending	. •		-	Bend	-	4	Program		\vdash	4	<u> </u>	Set-up
	-	Centre N	ot Concer	ntric	-	BOM/Route	\vdash	Grain				Over/Under Part Incorre	F	Temperature/Cure
	-	Cracks	- /p:	. // 4/	-	Broken/Damage/Defect	\vdash	Hardwa		navalified	┝	Part Lost/M		Weld
	\vdash	Crimp/Ki	пк/кірріе	y wave	-	Burrs	\vdash	4 '	ion Incomplete/U	•	\vdash	Part Moved		Wrong Stock Pulled
	\vdash	Crushing			-	Contamination Countersink	\vdash	-	tions Incomplete/I gned/off center	Unclear	\vdash	Positioned V		Tanong Stock Lanea
ļ	\vdash	Crushing Heat Trea			 	Cut Too Short	-	Mislab	=	,	\vdash	Power Loss/	-	Other
	\vdash	Inspectio		Tube	\vdash	Drawing	\vdash	Misrea			<u> </u>	J. 5 W.C. 1033/		100
	\vdash	Marks/Cl		iuse	\vdash	Drill Holes	\vdash	Off-set					W.	
	-	4	Sequence		\vdash	Finish	\vdash	4	Calibration					
	\vdash		vist in Tul		\vdash	Fit/Function	\vdash	-	Sequence					
1		, _ ,			I	1 ,	I	1						

Work Order ID 123635 Monday, August 18, 2014 2:35:23 PM						Page 2							
Item ID: Revision ID:					Accept	*N900	7* s	Setup Star	17	S1*	=		
Rem Name: Start Date: Required Date: Reference:	8/13/14	Start Qty: 2.00 Req'd Qty: 2.00		*2*		Cust Item] Customer:	ID:			Stop	, *N	S2*	
Approvals:	Process Pl	an:	Date:		Tooling:	D:	ate:	_	R	Run Star	^t *N	R1*	
	QC:		Date:		SPC (Y/N):	D:	ate:			Stop)	R2*	
Sequence ID/ Work Center II 120 *1 20* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 38 9-89]4-0	- 10-16
130 *120* Small Fab Small Fab		Small Fab Memo Deburr if nec	essary. 🕡	(A	0.00 0.00 DAS 38						,		
140 *1 4 0 * QC Quality Control		QC5- Inspect part comple	teness to step o	on W/O	9-80 _{0.00}								

DQA:			Date:						2244165 / 111				`DART		
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFOI	RIMANCE / U		/ork Order up	odate only	AEROSPACE		
±						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Orde	er: _									_		Water Jet	7		
Part N	lo.					Rework Scrap		Skid-tube Crosstul Machining Small Fa			Pro	Engineering Quality			
NCR N	۱o. <u>-</u>					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other		
Root	\neg				Desc	ription of work order update	ı	nitial	Act	tion	Sign &				
Cause	١	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector		
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Landi	ng (Gear				General		_		_	_		-		
		Bending				Bend		Folio/l	Program		Outside Dim	ensions	Pressure/Forced		
		Centre N	ot Conce	ntric		BOM/Route		Grain	•		Over/Under	tolerance	Set-up		
		Cracks				Broken/Damage/Defect		Hardwa	are	L	Part Incorre	ci	Temperature/Cure		
	Crimp/Kink/Ripple/Wave			e/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/M	issing	Weld		
	Cuffs				Contamination		instruc	tions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled			
		Crushing				Countersink		Misali	gned/off center		Positioned \	Vrong	-		
		Heat Tre				Cut Too Short		Mislab	eled		Power Loss/	Surge	Other		
	Inspection Strip in Tube				Drawing		Misrea	d	_						
		Marks/Cl	natter			Drill Holes		Off-set							
		Turning S	Sequence	!		Finish		Out of	Calibration						
		Wave/Tv	vist in Tul	be		Fit/Function		Out of	Sequence						

Work Ord				*123	3635*							Page
Item ID: Revision ID: Item Name:	D3575-1 Cargo Floor	Protector		Accept	*N900	0040	110	N *	Setup	Star Stop	17	S1*
Start Date: Required Date Reference:	8/13/14 : 8/18/14	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item Customer:	-				эш	*N	S2*
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:	_	-	Run	Start Stop	^IVI	R1*
Sequence ID/ Work Center I 150 *150* Packaging	D	Operation Description Identify as per dwg & Stoc	k Location:	Set Up/ Run Hours 0.00 0.00 0.00	Tool ID	Tool#	Code	Accep Qty	t Re Qt:	ject y	Reject Number	Insp. Stamp

160

QC21- Final Inspection - Work Order Release

0.00

1 60

Quality Control

Memo

0.00

14/10/16 H)

MF

14-(0-16

Page 3

WORK ORDER NON-CONFORMANCE / UPDATE Work Order: Disposition Rewark Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Quality Other	DQA:			Date: _												TRAAC"
Work Order: Part No.							WORK ORDER NON-	-CC	NFO	RMANCE / UP						AEROSPACE
Rework Skid-tube Crosstube Prod. Eng. Coor. Quality Other Suspected Unapproved Step Other Suspected Unapproved Chief Eng Description Date Verification QC Inspector Date Verification QC Inspector Design Description Date Verification QC Inspector Design Description Date Description Description Date Description Description Date Description Date Description Description Date Description Date Description Description Date Description Description Date Description Description Date Description Description Date Description Description D	QA Closed:			Date:							V	Vork Ord	ler up	odate only		
Root Cause Date Step Qty Description of work order update or non-conformance Chief Eng Description Description Description General Chief Eng Description Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief E	Work Order						DISPOSITION				AGAINST D	EPARTM	1ENT/	/PROCESS		
Part No. Scrap Use-as-is Suspected Unapproved Use-as-is VVOIR Order	· –		······································		_	Rework	1		Skid-tube	Crosstube	\neg		Water Jet		Engineering	
NCR No. Use-as-is Suspected Unapproved Use-as-is Large Fab Composite Rec/Store/Packaging Other Supplier Other Composite Other Other Composite Other Composite Other Composite Other Othe	Part No) .							l		} —	:	Pro			
Root Cause Date Step Qty Or non-conformance Chief Eng Description Design Doc/Data Equip/Tooling Handling/Pre Andersia Description Operator Offset/Setup Process Supplier Training Training Training Handling Gar Landing Gear Bending Gear General Bending Gear General Bending Centre Not Concentric BOM/Route Description Offwork order update Initial Action Date Verification Operator Chief Eng Description Description Description Date Verification Operator Chief Eng Description Date Verification Operator Chief Eng Description Date Verification Operator Chief Eng Description Date Verification Operator Chief Eng Description Date Verification Operator Chief Eng Description Date Verification Operator Chief Eng Description Date Verification Operator Chief Eng Description Date Verification Operator Chief Eng Description Date Verification Operator Chief Eng Description Date Verification Operator Chief Eng Date Verification Date Verification Operator Chief Eng Date Ve		_				_	·		Thern	moforming	Finishing	Red	/Stor	re/Packaging		Other
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design	NCR No	o					Suspected Unapproved			Large Fab	Composite			Supplier		
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data □ <t< td=""><td>Root</td><td></td><td></td><td></td><td></td><td>Descr</td><td>ription of work order update</td><td></td><td>nitial</td><td>Actio</td><td>on</td><td>Sign</td><td>&</td><td></td><td></td><td></td></t<>	Root					Descr	ription of work order update		nitial	Actio	on	Sign	&			
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Handling/Pre Material Departor Departo	Doc/Data											İ			l	
Material	Equip/Tooling															
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Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up								FAI	ULT CA	TEGORY						
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Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld	<u> </u>	_		. /0:	Natarra		1 - 1	\vdash	4		auglified				\vdash	,
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	-	Crushing		-	4	\vdash	1	-	}	_		-		Other		
Inspection Strip in Tube Drawing Misread	-	Heat Treat		\vdash	-		-		L		2000/	23180	ш			
Marks/Chatter Drill Holes Off-set		_	•	•	Tube	-	- ·	\vdash	4							
Turning Sequence Finish Out of Calibration	-	_	•			-	4	\vdash	4				· ·			
Wave/Twist in Tube Fit/Function Out of Sequence		\dashv	=		e			\vdash	4							

Picklist Print

Monday, August 18, 2014 2:35:22 PM

Work Order ID: 123635

123635

Parent Item:

D3575-1

D3575-1

Location

MAT019

TPI

Parent Item Name: Cargo Floor Protector

Start Date: 8/13/14

Required Date: 8/18/14

Start Qty: 2.00

Required Oty: 2.00

Comments:

IPP Rev : A New Issue 07-01-22

Component Item ID/
Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location Last Location

Route Seq ID

Unit of Measure Hand

Qty per Kit Total Qty on

**

Qty

Qty

Issued

Date Issued

Status

Page 1

MLEXS.125-F60029-04

Purchased

No

100

5,110.630

8 19

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Loc Oty Loc Code

sf

2991.525 106 m126425 160.925 m127934 699.6 m128746 2025

m129759

124866

2119.10588 2119.10588

DQA:			Date:			WORK ORDER NON	~	ארסו	DRAANCE / LIDDATE				~DAR	1
QA Closed:			Date:			WORK ORDER NON-		JNFOI	RIVIANCE / OPDATE	W	ork Order up	date only	AEROSPA	CE
M						DISPOSITION			AGAINST	DE	PARTMENT	PROCESS		
Work Orde	er: -	-				Rework			Skid-tube Crosstube		1	Water Jet	Engineering	7 I
Part N	lo.					Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality	
						Use-as-is		Thern	moforming Finishing		Rec/Sto	re/Packaging	Other _	4
NCR N	10					Suspected Unapproved			Large Fab Composite	<u> </u>	J	Supplier		
Root					Desci	ription of work order update		nitial	Action		Sign &			
Cause	1	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspecto	r
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Equip/Tooling														
Handling/Pre						!								
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Operator														
Offset/Setup														
Process														
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Landi	ng (Gear				General		_		_	_			
		Bending				Bend		Folio/I	Program	L	Outside Dim	ensions	Pressure/Forced	
		Centre N	ot Concei	ntric		BOM/Route		Grain		Ĺ	Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardw	are	L	Part Incorre	cí _	Temperature/Cu	re
		Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/M	issing	Weld	
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved	L	Wrong Stock Pull	ed
		Crushing				Countersink		Misali	gned/off center		Positioned \	Vrong		
		Heat Trea				Cut Too Short		Mislab	eled		Power Loss/	'Surge	Other	
	Inspection Strip in Tube				Drawing		Misrea	nd						
		Marks/Cl				Drill Holes		Off-set						
		4	Sequence	!		Finish		Out of	Calibration					
		Wave/Tv				Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	23635
Description: Cabin Floor Protector	Part Number:	D3575-1
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	Ø 3.00 l	7		V=3km-01	
1.00	+/-0.030	1.00	1		T=51cm-06	
3.50	+/-0.030	3.50	1			
16.00	+/-0.030	16-00				
23.13	+/-0.030	23.13	/			
26.88	+/-0.030	2688	/			
27.69	+/-0.030	27.69	7			
4.25	+/-0.030	4.25				
9.63	+/-0.030	9,63	~			
16.13	+/-0.030	16.13	/			
28.06	+/-0.030	29.06				
32.15	+/-0.030	32.15	~			
2.00	+/-0.030	200	_			
3.50	+/-0.030	3.50				
14.25	+/-0.030	14.25	~			
25.13	+/-0.030	25.13	_			
29.38	+/-0.030	29.39	/			
30.13	+/-0.030	30.13				
1.25	+/-0.030	1.25				
3.38	+/-0.030	3.38	_			· · · · · · · · · · · · · · · · · · ·
5.00	+/-0.030	7,00	_			
6.50	+/-0.030	6.50				
26.13	+/-0.030	26.13	1			
31.50	+/4 9 \$030		DAS			

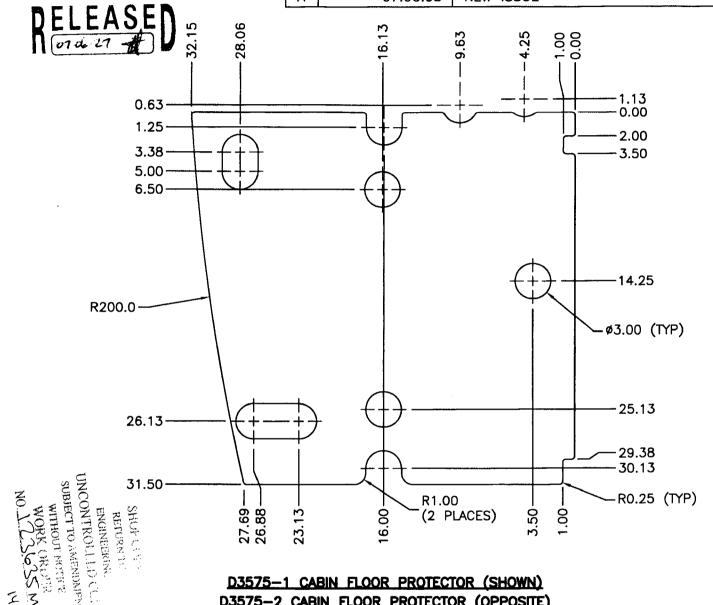
Measured by: De 9-89 Audited by: 9-89 Prototype Approval: N/A

Date: 14-10-16 Date: N/A

Rev	Date	Change	Revised by,	Approved
Α	08.02.29	New Issue	KJ/DD 🥋	X
			V	•







D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

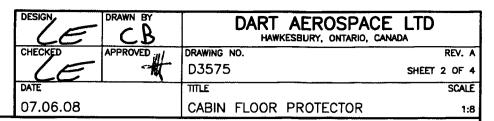
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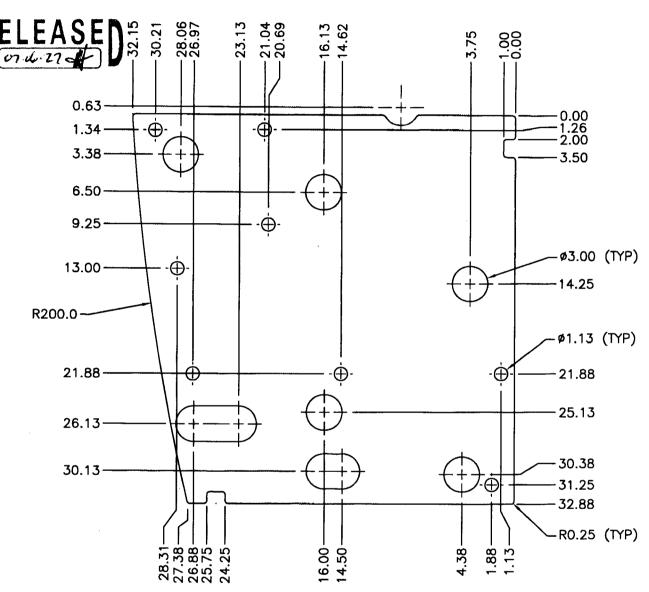
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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D3575-3 CABIN FLOOR PROTECTOR

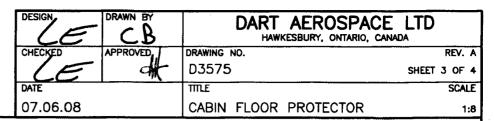
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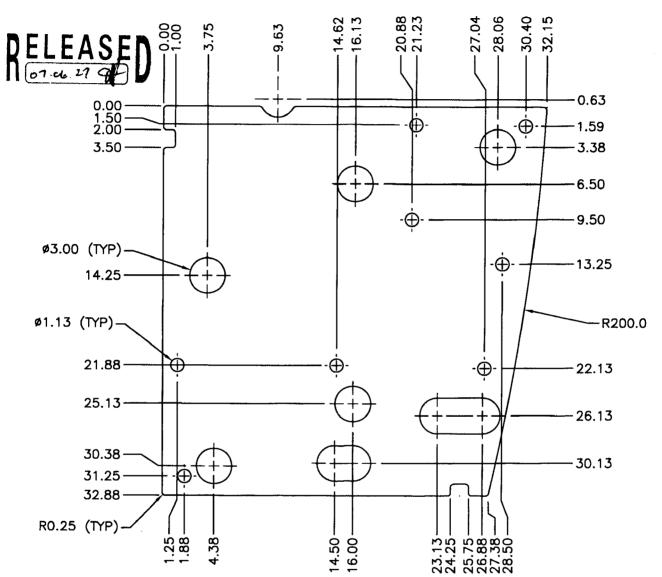
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

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D3575-4 CABIN FLOOR PROTECTOR

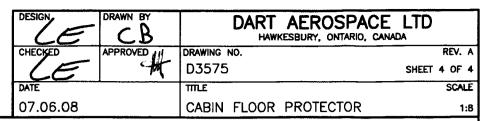
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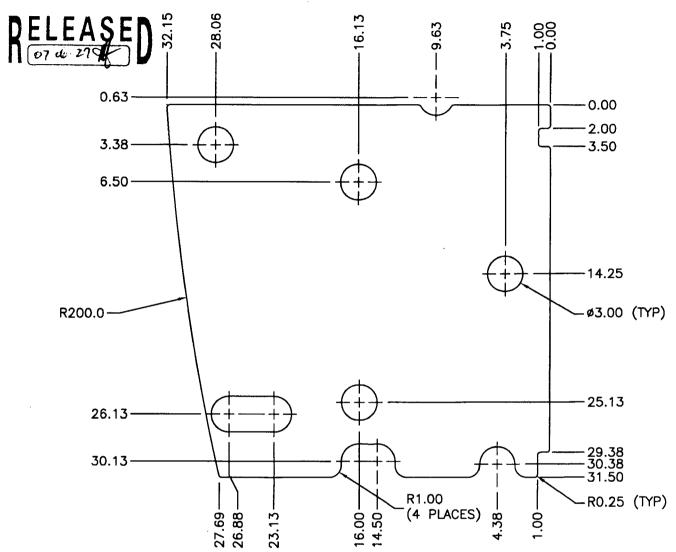
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

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D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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